

**Work Order ID 60905**

Monday, July 26, 2010 2:13:23 PM



Page 1

Item ID: D2938-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH Out, 206

Start Date: 7/26/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 8/2/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *[Signature]*Date: *10-7-24*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2938	Rev C

100



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

0.00

0.00

*L.A 10/08/02**4**0*

110



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

Machine Keyway and inspect per attached dimension sheet

0.00

0.00

*SA 10/08/05**4**0*

120



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

Memo

0.00

0.00

*L.A 10/08/02**4**0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Cust Item ID:

Required Date: 8/2/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

JIT 10/08/09

4 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

ml 10 08 09 (21)

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:00pm FINISH TIME: 1:30pm OVEN TEMPERATURE: 320°F

= 294 10/08/10

4 0

W/O:		WORK ORDER CHANGES							
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**Work Order ID 60905**

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Page 3

Item ID: D2938-1

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Required Date: 8/2/2010 Req'd Qty: 4.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

m 10 08 10 (4)

170

Identify as per dwg &amp; Stock Location: 428A

0.00

Packaging

Memo

0.00

Packaging

10/8/10 sl (40)

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/08/11 J

mf 10-8-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, July 26, 2010 2:13:27 PM

Page 1

Work Order ID: 60905

Parent Item: D2938-1

Parent Item Name: Saddle LH Out, 206

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC  
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	26.0000	1	4			



Saddle Billet, 7075



Location

Loc Qty

Loc Code

MAT042

26

59196

26

4.000

B.A 10/08/02

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <i>60905</i>
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b> D2938-1
<b>Inspection Dwg:</b> D2938 Rev. C		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.133	0.133	0.133	0.133		Deep throat mic. / 118-120
B	0.100	0.140		0.136	0.136	0.136	0.136		" "
C	0.100	0.140		0.120	0.120	0.120	0.120		" "
D	0.210	0.230		0.223	0.223	0.223	0.223		" "
E	1.245	1.255		1.250	1.250	1.250	1.250		vern / GA-01
F	1.245	1.255		1.250	1.250	1.250	1.250		" "
G	2.495	2.505		2.500	2.500	2.500	2.500		" "
H	0.510	0.515		.510	.510	.510	.510		" " 2.512
I	1.572	1.582		1.577	1.577	1.577	1.577		" "
J	2.495	2.505		2.500	2.500	2.500	2.500		" "
K	0.257	0.262		0.259	0.259	0.259	0.259		" "
L	0.312	0.317		0.314	0.314	0.314	0.314		" "
M	0.235	0.240		.237	.237	.237	.237		" " Mic 2704
N	0.100	0.140		0.111	0.111	0.111	0.111		mic / GA-03
O	0.540	0.560		0.551	0.551	0.551	0.551		vern / GA-01
P	0.490	0.510		0.500	0.501	0.500	0.500		" "
Q	3.715	3.725		3.720	3.720	3.720	3.720		" "
R	2.720	2.760		2.745	2.745	2.745	2.745		" "
S	0.240	0.270		0.250	0.250	0.250	0.250		" "
T	0.100	0.180		0.130	0.130	0.130	0.130		" "
U	1.625	1.635		1.630	1.630	1.630	1.630		" "
V	1.362	1.372		1.367	1.367	1.367	1.367		" "
W	0.316	0.321		0.316	0.316	0.316	0.316		" "
X	1.250	1.270		1.263	1.264	1.265	1.265		HAAS3 / DIAL indicator
Y	1.565	1.585		1.576	1.577	1.577	1.577		HAAS3 / DIAL INDICATOR
Z	0.178	0.198		0.188	0.188	0.188	0.188		RAD GAGE
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>H.A.</i>
Date: <i>10/08/07</i>

Audited by: <i>DTA</i>
Date: <i>10/08/09</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

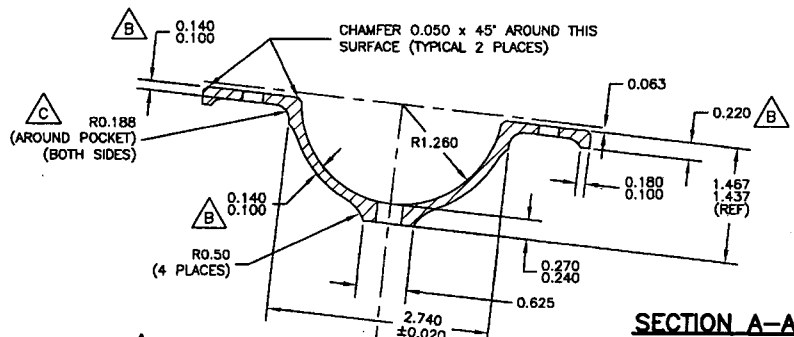
W/O:			WORK ORDER CHANGES					
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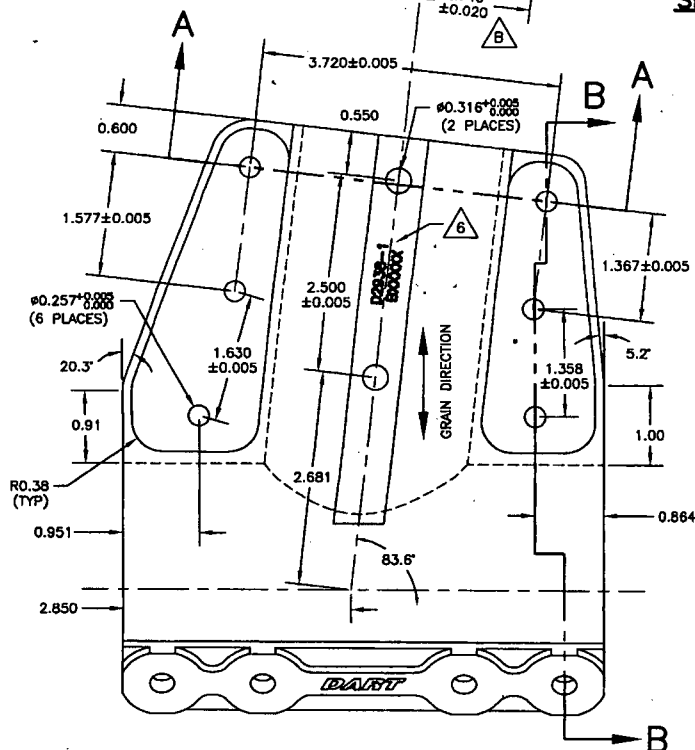
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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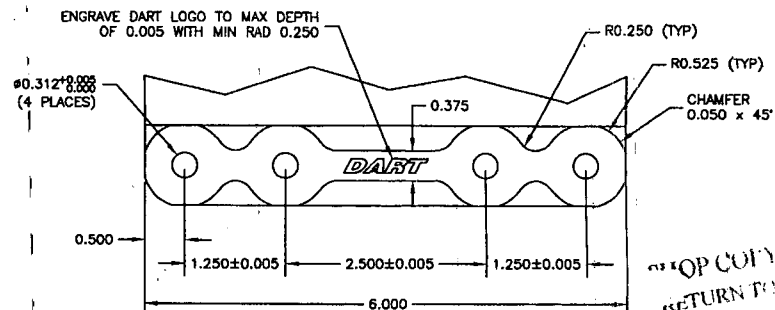
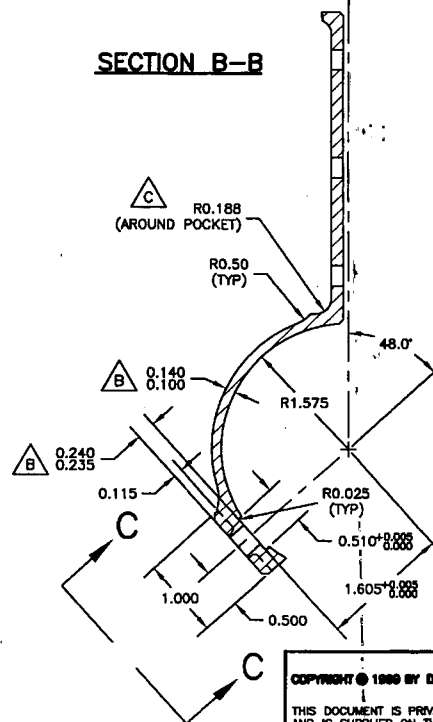
**NOTE:** Date & initial all entries



SECTION A-A



SECTION B-B



VIEW C-C

D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	PH	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE
		DART DART AEROSPACE USA, INC. BELLINGHAM, WA
		DRAWING NO. D2938
		REV. C
		SHEET 1 OF 1
		SCALE

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07.02.12

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WITHOUT NOTICE  
WORK ORDER NO. 60905

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